

Date: Friday, 5/25/2007 8:37:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 32653
 Estimate Number : 10314
 P.O. Number : NIA Part Number : D265613
 This Issue : 5/25/2007 S.O. No. : NIA Drawing Number : D2656 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : SMALL /MED FAB Drawing Revision : D
 Previous Run : 31889 Material : NIA
 Written By : Due Date : 6/12/2007 Qty: 30 Um: Each
 Checked & Approved By : ADD 05.28
 Comment : Est: F 02.10.25 Re-format KJ/RF
 Est Rev:G Now on Waterjet 06-07-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8500 sf(s)/Unit Total : 25.5000 sf(s) M10481 (4)
 1010/1025/A21/6aA SHEET B# M104752 (26) SAD 07/06/20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: D
 Prog Rev: D

2-Deburr if necessary

SAD 07/06/20 Q.M. 07.06.20 (30)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/20 (30)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/06/20 (30)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

SAD 07/07/16 (30)
 SAD 07/07/18 (30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:37:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32653

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Counted

Comment: INSPECT WORK TO CURRENT STEP

En 07/07/18

(30)

7.0

POWDER COATING

POWDER COATING



M1104846



(30X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l

07/07/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m 07/07/21



(30)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(30X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-PIS

m-l 07/07/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



U 07-07-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

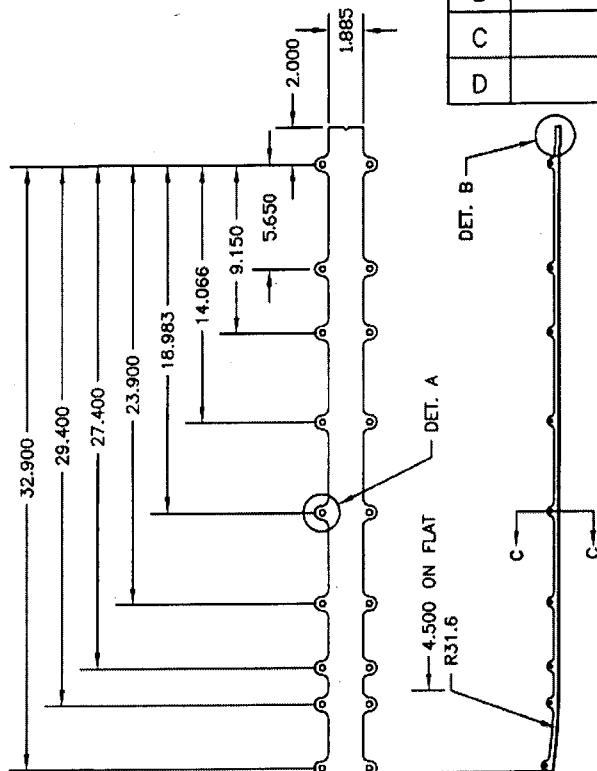
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

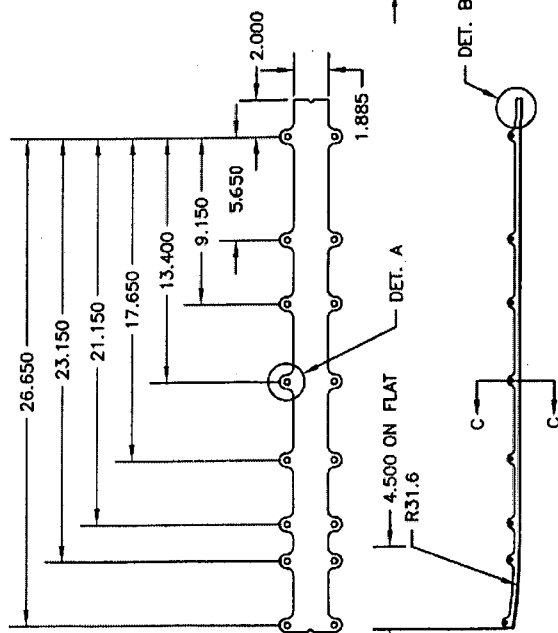


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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

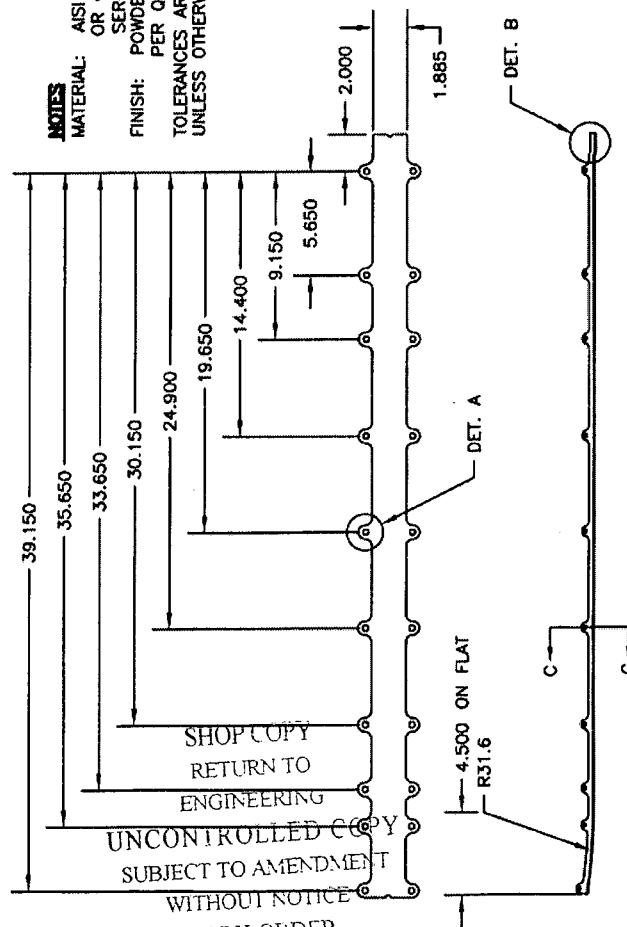
D2656-13



D2656-11



D2656-15



NOTES:
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA G40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

RELEASED
 05.09.08

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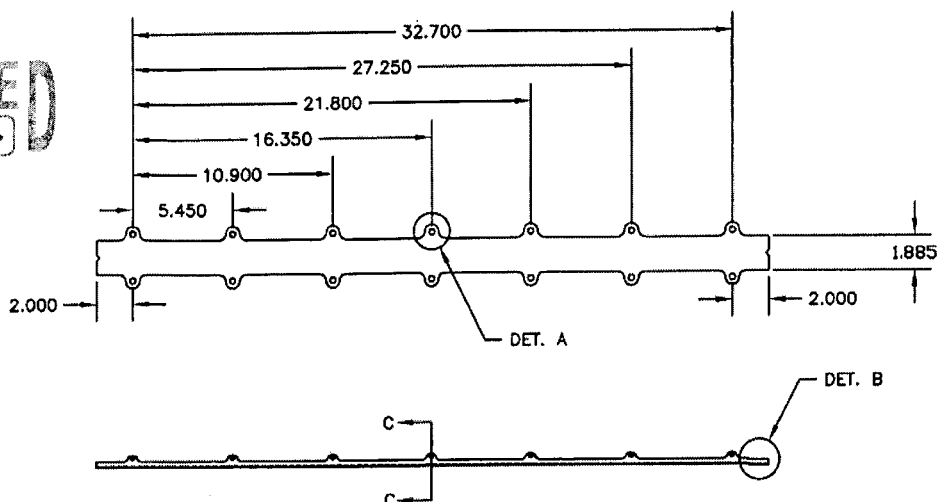
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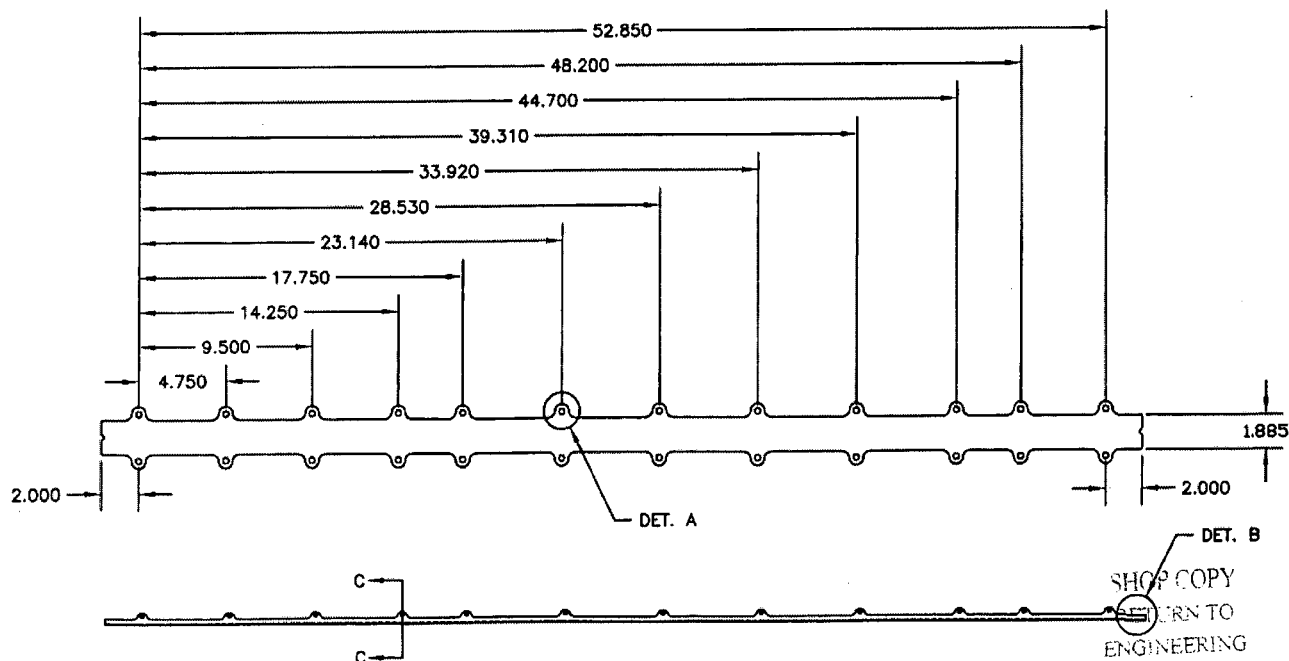
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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D2656-21



D2656-23



NOTES

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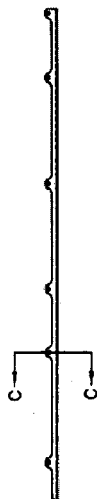
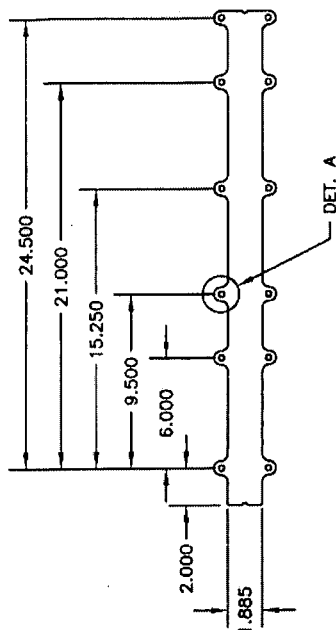
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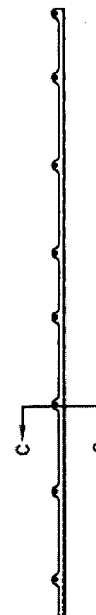
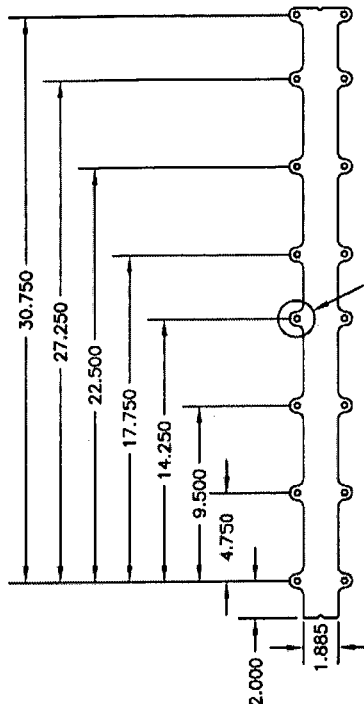


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

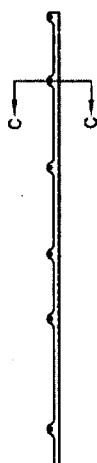
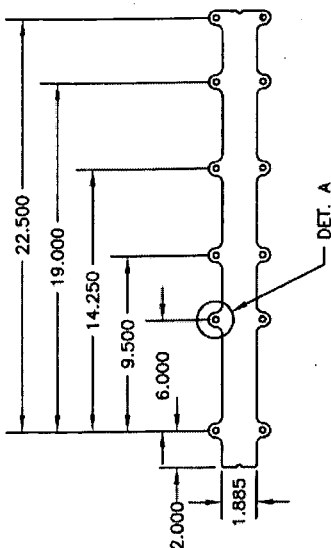


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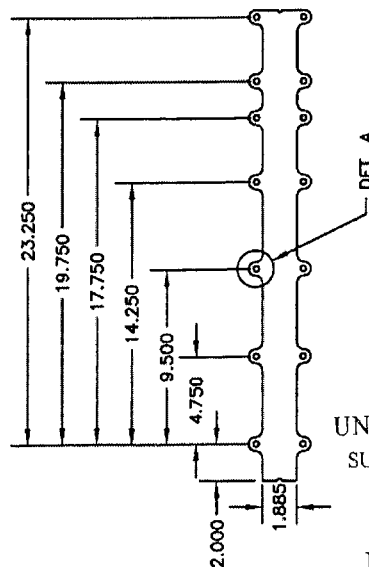


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FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

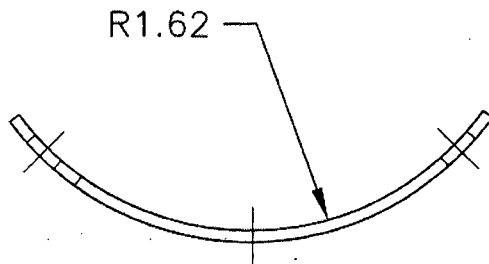
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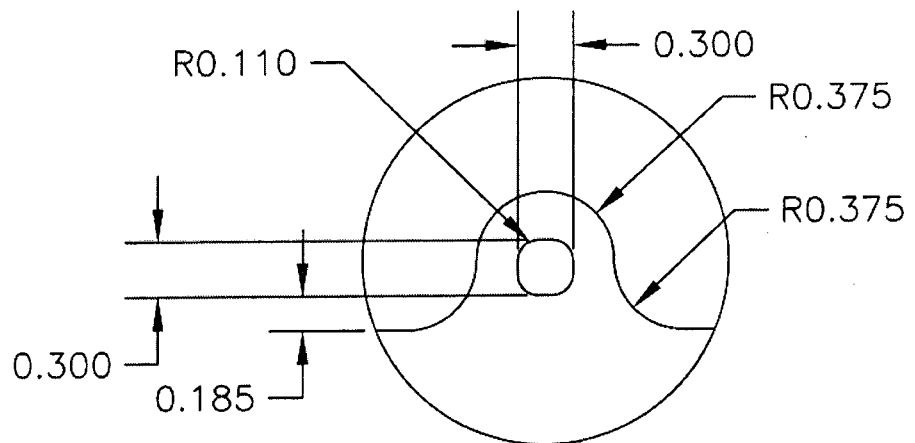
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

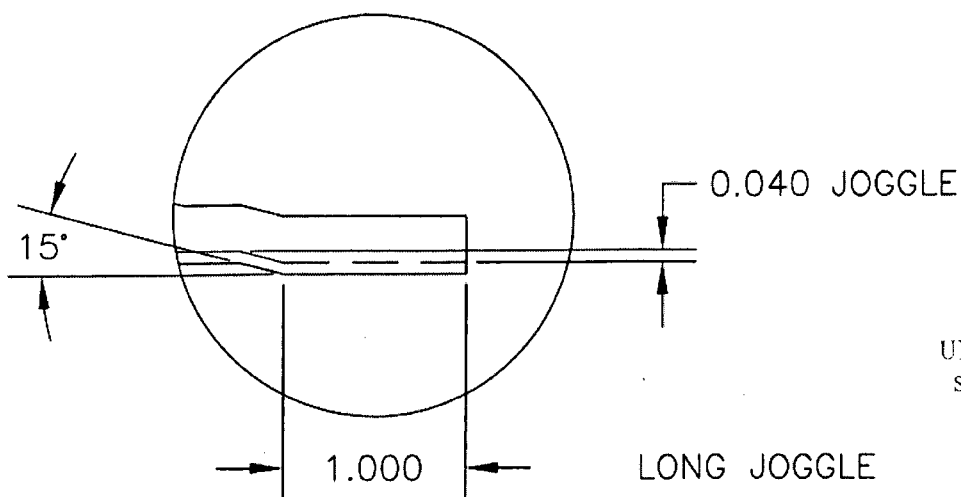


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DETAIL A



DETAIL B



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